

Work Order ID: 120026

June 03 14:7:11:40 AM

\*120026\*

Page 1

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 6/03/14

Start Qty: 1.00 \*1\*

Required Date: 6/03/14

Req'd Qty: 1.00 \*1\*

Reference:

Approvals: Process Plan: MLJ

Date: 14-06-03 Tooling: Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N): Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw-Nbr	Revision Nbr
D3391	I

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo

0.00

Turn as per Folio FA599 Rev: A & Dwg D3391 Rev: A

14/06/19

\*\*\*\*REMOVE STEADY REST AND MACHINING MARKS\*\*\*\*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

14/06/20

112

QC5- Inspect part completeness to step on W/O

0.00

\*112\*

QC

Quality Control

Memo

0.00

DAS  
9  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

**FAULT CATEGORY**

Landing Gear	General	General	General	General
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		Other

**Work Order ID 120026**

June-03-14 7:11:40 AM

**\*120026\***

Page 2

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 6/03/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> HAAS 1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: A & Dwg D3391 Rev: A 2-Deburr	0.00 0.00	<i>OK/OK</i>	<i>14/10/11</i>		1			
130 <b>*130*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>OK/OK</i>	<i>14/10/11</i>		1			
140 <b>*140*</b> QC Quality Control	QC8- Inspect parts - second check Memo ***INSPECT INSIDE BORE***	0.00 0.00				1	0		DAS 44 14/10/12 9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____  Part No. _____  NCR No. _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS														
	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering	Quality	Other
	Suspected Unapproved																	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General			
	Bending	Bend	Folio/Program	Outside Dimensions
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved
	Crushing	Countersink	Misaligned/off center	Positioned Wrong
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge
	Inspection Strip in Tube	Drawing	Misread	Pressure/Forced
	Marks/Chatter	Drill Holes	Off-set	Set-up
	Turning Sequence	Finish	Out of Calibration	Temperature/Cure
	Wave/Twist in Tube	Fit/Function	Out of Sequence	Weld
				Wrong Stock Pulled
				Other

Work Order ID 120026

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Page 3

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 6/03/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

\*150\*

Skidtubes

Skidtubes

0.00

1

c

14-10-14 DGC

Skidtubes

Memo

0.00

160

\*160\*

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

170

\*170\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS  
03  
9:58

DP 14-10-15

H-4.08

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
Suspected Unapproved <input type="checkbox"/>			Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear				General											
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
												<input type="checkbox"/> Other			

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**\*120026\***

Page 4

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 6/03/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

**\*180\***

Skidtubes

Skidtubes

0.00

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217  
Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2  
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

DP

14-10-22

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____  Part No. _____  NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework	Scrap	Skid-tube	Crosstube	Water Jet	Engineering		
	Use-as-is	Suspected Unapproved	Machining	Small Fab	Prod. Eng. Coor.	Quality		
		Thermoforming	Finishing	Rec/Store/Packaging	Other			
		Large Fab	Composite	Supplier				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General			
	Bending	Bend	Folio/Program	Outside Dimensions
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved
	Crushing	Countersink	Misaligned/off center	Positioned Wrong
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge
	Inspection Strip in Tube	Drawing	Misread	Pressure/Forced
	Marks/Chatter	Drill Holes	Off-set	Set-up
	Turning Sequence	Finish	Out of Calibration	Temperature/Cure
	Wave/Twist in Tube	Fit/Function	Out of Sequence	Weld
				Wrong Stock Pulled
				Other

**Work Order ID 120026**

June-03-14 7:11:40 AM

**\*120026\***

Page 5

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***Start Date: 6/03/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	<b>*NR1*</b>
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-09 14-10-22
Quality Control	Memo	0.00							

200 <b>*200*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				1	14-10-22
Hand Finishing	Memo	0.00					

210 <b>*210*</b> QC	QC7-Inspect Chemical Conversion Coat	0.00				DAS 03 9-09	14-10-23
Quality Control	Memo	0.00					

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____  NCR No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General		
Bending	Bend		Outside Dimensions
Centre Not Concentric	BOM/Route		Over/Under tolerance
Cracks	Broken/Damage/Defect		Part Incorrect
Crimp/Kink/Ripple/Wave	Burrs		Part Lost/Missing
Cuffs	Contamination		Part Moved
Crushing	Countersink		Positioned Wrong
Heat Treat	Cut Too Short		Power Loss/Surge
Inspection Strip in Tube	Drawing		Pressure/Forced
Marks/Chatter	Drill Holes		Set-up
Turning Sequence	Finish		Temperature/Cure
Wave/Twist in Tube	Fit/Function		Weld
			Wrong Stock Pulled
			Other

**Work Order ID 120026**

June-03-14 7:11:40 AM

**\*120026\***

Page 6

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 6/03/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

**\*220\***

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1- Instal spacers as per dwg D3391  
 A/R Magnabond 6398 Batch: 129172  
 exp. date: 14-12-30  
 cure time 12hrs as per QSI0015

2- Grind crossbolts flush

3- Back drill using #9 drill

4- Touchup Magnabond

5- Deburr

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

**\*230\***

QC

Quality Control

Memo

0.00

14-10-28

DAS

9

9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General								
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	
Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	
Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	
Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	
Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		
Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	
Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>		
Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>		
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>		
Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>		

**Work Order ID 120026**

June-03-14 7:11:40 AM

**\*120026\***

Page 7

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***Start Date: 6/03/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

235

Pressure Wash per QSI005 4.3

0.00

**\*235\***

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

11 f all 16 30

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*240\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:10 OVEN TEMPERATURE: 320°  
FINISH TIME: 1:401 8 4-10-30 240

250

QC3- Inspect Part Finish

0.00

**\*250\***

QC

Memo

0.00

Quality Control

1 8 all 4-10-03 9-89 **DAS  
15**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Skid-tube	Crosstube	Water Jet	Engineering		
	Scrap	Machining	Small Fab	Prod. Eng. Coor.		Quality	
NCR No. _____	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other		
	Suspected Unapproved	Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General			
	Bending	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric	Grain	Over/Under tolerance	Set-up
	Cracks	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing	Misaligned/off center	Positioned Wrong	Power Loss/Surge
	Heat Treat	Mislabeled	Other	
	Inspection Strip in Tube	Misread		
	Marks/Chatter	Off-set		
	Turning Sequence	Out of Calibration		
	Wave/Twist in Tube	Out of Sequence		

**Work Order ID 120026****\*120026\***

Page 8

June-03-14 7:11:40 AM

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 6/03/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 <b>*260*</b> HandFinish	HandFinishing	0.00							<i>14 of 111 11/10/03</i>
Hand Finishing	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/R Sikaflex-241/-291 <i>11130227</i>								
	Sikaflex expiry date: <i>15/08</i>								
	3- INSTALL WEARPLATES AS PER DWG								
270 <b>*270*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							<i>DAS 38 9-89</i>
Quality Control	Memo	0.00							<i>14-11-9</i>
280 <b>*280*</b> Packaging	Identify as per dwg & Stock Location: <i>W16</i>	0.00	<i>0412-742-0431</i>	<i>13115486</i>					<i>14 of 111 11/10/03</i>
Packaging	Memo	0.00							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____  NCR No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube	<b>General</b> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/>				Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/>				

Work Order ID 120026

June-03-14 7:11:40 AM

\*120026\*

Page 9

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 6/03/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/03/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

290

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*290\*

QC

Quality Control

Memo

0.00

0.00

14/11/14 JJ

RT 14-11-04

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order-update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

## DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

## AGAINST DEPARTMENT/PROCESS

Skid-tube   
 Machining   
 Thermoforming   
 Large Fab

Crosstube   
 Small Fab   
 Finishing   
 Composite

Water Jet   
 Prod. Eng. Coor.   
 Rec/Store/Packaging   
 Supplier

Engineering   
 Quality   
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General			
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Set-up <input type="checkbox"/>
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Weld <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>	Other <input type="checkbox"/>
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>	
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	

# Picklist Print

June-03-14 7:11:43 AM

Page 1

Work Order ID: 120026

\*120026\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	14.0000	1	1		14/08/18	

\*D4095-047\*

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	14	
102241	2	
108289	12	

D4095-049

\*D4095-049\*

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	9	
109670	9	B120495

D6014-090

\*D6014-090\*

ALUMINUM EXTRUSION

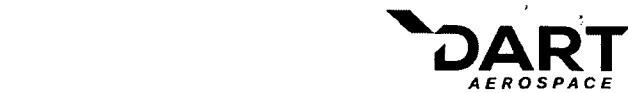
Location	Loc Qty	Loc Code
LG003	63	
79742	17	
86063	46	

14/08/18

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected Unapproved			Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General			
	Bending	Bend	Folio/Program	Outside Dimensions
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved
	Crushing	Countersink	Misaligned/off center	Positioned Wrong
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge
	Inspection Strip in Tube	Drawing	Misread	Pressure/Forced
	Marks/Chatter	Drill Holes	Off-set	Set-up
	Turning Sequence	Finish	Out of Calibration	Temperature/Cure
	Wave/Twist in Tube	Fit/Function	Out of Sequence	Weld
				Wrong Stock Pulled
				Other

# Picklist Print

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Page 2

Work Order ID: 120026

\*120026\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

232.0000

4

4  
\*\*  
14-10-23

\*D3670-4-200\*

Bushing

Location	Loc Qty	Loc Code
FG	10	
87709	10	
LG001	222	
103880	15	
109108	206	
96240	1	

D2646

Manufactured No

270

Each

62.0000

1  
1  
\*\*

14-10-23

\*D2646\*

Aft Cap

Location	Loc Qty	Loc Code
FG	4	
85848	2	
90495	2	
FP001	58	
103306	3	13119656
107857	1	X
110816	13	
113830	31	
114495	10	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing	Countersink	Misaligned/off center	Positioned Wrong	
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube	Drawing	Misread		
	Marks/Chatter	Drill Holes	Off-set		
	Turning Sequence	Finish	Out of Calibration		
	Wave/Twist in Tube	Fit/Function	Out of Sequence		

# Picklist Print

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Work Order ID: 120026

**\*120026\***  
**\*D3391-025\***

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Start Qty: 1.00

Required Date: 6/03/14

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,238.000

2

2

\*\*

**\*D3672-1\***

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
85222	10	
Return2014	34	
80369	34	
ST060	1194	
103845	4	
112218	500	
113581	500	
93886	62	
99099	128	

ALS4-1032-130

AELS4-1032-130 Purchased No

260

Each

7,504.000

14

14

\*\*

**\*A1 S4-1032-130\***

Rivnut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7399	
M128649	7399	
ST279	48	
M128211	48	
st510	57	
M126109	57	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**Work Order update only 

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General		
Bending	Bend	<input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Part Incorrect <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>
Cuffs	Contamination	<input type="checkbox"/>	Part Moved <input type="checkbox"/>
Crushing	Countersink	<input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>
Heat Treat	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Other <input type="checkbox"/>
Marks/Chatter	Drill Holes	<input type="checkbox"/>	
Turning Sequence	Finish	<input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>	

# Picklist Print

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Work Order ID: 120026

**\*120026\***  
**\*D3391-025\***

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

727.0000

8

8

\*\*

all w/ a 103

Rivnut

ALS7-1032-225

<u>Location</u>	<u>Loc Oty</u>	<u>Loc Code</u>	
FG	30		
M127028	30	1A130565	<u>x8</u>
FP001	423		
M128649	423		
ST280	248		
M127028	10		
M128179	238		
st555	26		
M127092	26		

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear		General					
Bending		Bend		Folio/Program		Outside Dimensions	
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect	
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing	
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved	
Crushing		Countersink		Misaligned/off center		Positioned Wrong	
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge	
Inspection Strip in Tube		Drawing		Misread		Other	
Marks/Chatter		Drill Holes		Off-set			
Turning Sequence		Finish		Out of Calibration			
Wave/Twist in Tube		Fit/Function		Out of Sequence			

# Picklist Print

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Work Order ID: 120026

\*120026\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased No

270 Each

2,750.000 6 6

\*\*

\*AN3C4A\*

Bolt

6/14/14 03

Location	Loc Qty	Loc Code	
FG	20		
122814	20	M129520	✓6
Return2014	9		
124221	9		
ST350	13		
125388	3		
M128606	6		
M128739	4		
ST350/513	26		
M128606	26		
ST512	3		
124221	3		
ST513	2679		
M127410	1		
M127832	62		
M128634	616		
M128879	2000		

AN3C5A

Purchased No

270 Each

991.0000 4 4

\*\*

\*AN3C5A\*

Bolt

6/14/14 03

Location	Loc Qty	Loc Code	
FG	5		
122800	5	M130358	✓4
ST350	386		
M128973	186		
M129198	200		
ST513	600		
M128911	600		

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality		
	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other		
	Suspected	Unapproved	Large Fab	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions
Bending	Bend	Grain	Pressure/Forced
Centre Not Concentric	BOM/Route	Hardware	Set-up
Cracks	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Instructions Incomplete/Unclear	Weld
Cuffs	Contamination	Misaligned/off center	Wrong Stock Pulled
Crushing	Countersink	Mislabeled	Power Loss/Surge
Heat Treat	Cut Too Short	Misread	Other
Inspection Strip in Tube	Drawing	Off-set	
Marks/Chatter	Drill Holes	Out of Calibration	
Turning Sequence	Finish	Out of Sequence	
Wave/Twist in Tube	Fit/Function		

# Picklist Print

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Work Order ID: 120026

**\*120026\***  
**\*D3391-025\***

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

5,404.000

10

10

\*\*

ll dlo3

**\*NAS1149C0332R\***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
GA	825		
125654	825	AL130325	x10
Return2014	41		
122063	41		
ST292	1380		
124580	8		
125654	8		
m128591	1364		
st510	3158		
m126319	61		
m127306	2500		
m127410	563		
m127831	34		

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General			
	Bending <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
	Centre Not Concentric <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
	Cracks <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
	Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
	Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>		
	Marks/Chatter <input type="checkbox"/>	Off-set <input type="checkbox"/>		
	Turning Sequence <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
	Wave/Twist in Tube <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

DART AEROSPACE LTD		Work Order:	120026
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: I		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.000	✓		tape	LG-11
3.500	+/-0.010	3.499	-		vern	CNC-08
Ø3.200	+/-0.010	3.199	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 0.060 chamfer	+/-0.010	30° X.060	-			
88.93	+/-0.030	88.936	✓		tape	LG-11

Measured by: *mont*

Date: 14/10/11

Audited by:

Date:

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.506			vern CNC 2	
7.500	+/-0.010	7.495			✓	
27.750	+/-0.010	27.749			Haas I	
31.750	+/-0.010	31.750			✓	
35.250	+/-0.010	35.249			✓	
3.300	+/-0.010	3.30			vern CNC 2	
0.200	+/-0.010	.199			✓	
3.520	+/-0.010	3.513			✓	
0.687	+0.010/-0.000	0.686			✓	
R0.062	+/-0.010	0.62			✓	
Ø0.484	+0.005/-0.001	0.484			gage pin	

Measured by: *mont*

Date:

Audited by: *FK*

Date: 14/10/12

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue	P/O D3391-015/-025	KJ/JLM
B	06.06.19	Dwg revision update		KJ/JLM
C	07.04.20	Ø0.208 dimension removed		KJ/JLM
D	07.09.06	0.400 dimension removed		KJ/JLM
E	07.11.23	Dwg Rev. updated		KJ/EC/DD
F	09.04.27	Dimensions updated per Rev H and NCR09-028		KJ/JLM
G	09.11.16	Dimension 0.200 removed		KJ
H	11.06.21	Dimension 44.995 removed		KJ
I	12.05.15	Dwg Rev updated		KJ
J	12.05.23	Dimension updated		KJ
K	12.10.15	88.93 dimension removed		KJ
L	12.11.28	88.93 dimension added		KJ <i>mont</i> M

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

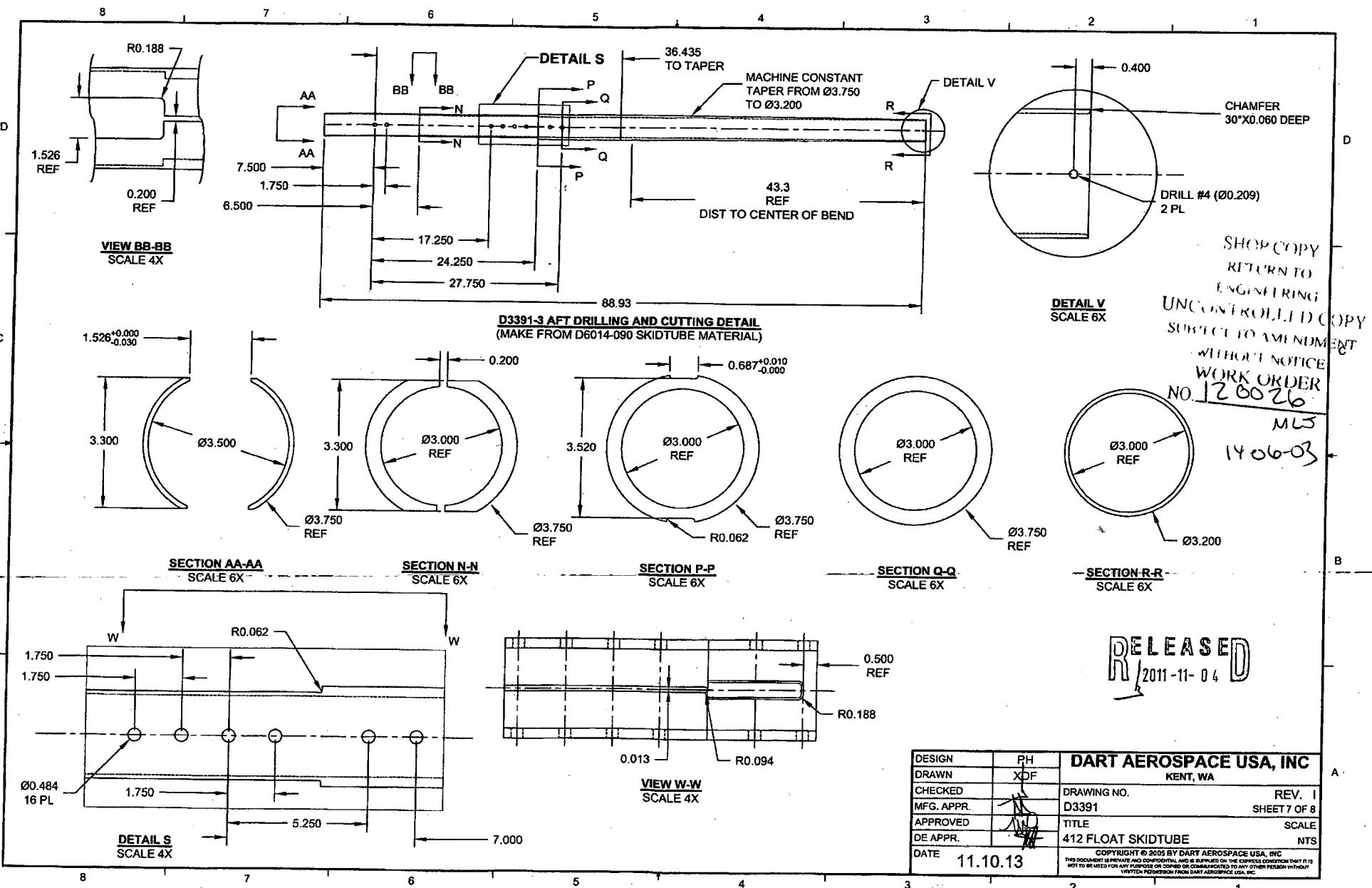
Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Faults	Other
Bending	Bend	Folio/Program	Outside Dimensions
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved
Crushing	Countersink	Misaligned/off center	Positioned Wrong
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge
Inspection Strip in Tube	Drawing	Misread	Pressure/Forced
Marks/Chatter	Drill Holes	Off-set	Set-up
Turning Sequence	Finish	Out of Calibration	Temperature/Cure
Wave/Twist in Tube	Fit/Function	Out of Sequence	Weld
			Wrong Stock Pulled
			Other



RELEASED  
12/2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED		DRAWING NO.	REV. I	
MFG. APPR.		D3391	SHEET 7 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC		
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DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____		<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>						
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering					
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>			Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
		Suspected Unapproved <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
<b>FAULT CATEGORY</b>											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other							
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									